

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization  
International Bureau



(43) International Publication Date  
17 February 2005 (17.02.2005)

PCT

(10) International Publication Number  
**WO 2005/015318 A1**

(51) International Patent Classification<sup>7</sup>:

**G03F 7/40**

(81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NI, NO, NZ, OM, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(21) International Application Number:

PCT/EP2003/007797

(22) International Filing Date: 17 July 2003 (17.07.2003)

(25) Filing Language: English

(26) Publication Language: English

(84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **MACHUEL, Gilbert** [FR/FR]; 13 Le Colombier, F-60440 Boissy Fresnoy (FR). **GERARD, Patrick** [FR/FR]; 62 rue Saint Jean, F-50400 Granville (FR).

(74) Agent: **VIKTOR, Rainer**; Vossius & Partner, Siebertstr. 3, 81675 München (DE).

Published:

— with international search report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

WO 2005/015318 A1

(54) Title: APPARATUS AND METHOD FOR TREATING IMAGING MATERIALS

(57) Abstract: An apparatus and method for improving the durability of an image on an imaging material, including increasing the press run length or a printing plate. The apparatus and method can involve the use of, as an example but not restricted to, an imaging device, a pre-bake oven, a processor, and a post-process treatment unit that employs infrared lamps adapted to irradiate the image.

## APPARATUS AND METHOD FOR TREATING IMAGING MATERIALS

### Field of the Invention

5

This invention relates to an apparatus and method for treating imaging materials, for example, resists and lithographic printing plates. The invention finds particular, but not exclusive, use in relation to thermal lithographic printing plates.

### 10 Background

Thermal lithographic plates are plates that are exposed or imaged by infrared radiation and/or heat. With certain plates the infrared radiation may initiate a photochemical reaction in, for example, an onium compound, present in a coating on the plates. In such embodiments an 15 infrared dye, also present in the coating, acts as a photosensitiser, absorbing the infrared radiation and sensitising the decomposition of the onium compound. With certain other plates, heat is itself the direct cause of imaging and is not believed to induce either a chemical decomposition of components within the coating or a photochemical reaction. In such embodiments, heat may be delivered to plates in a platesetter by a number of methods 20 including, for example, contacting the plates with a heated body, or using charged particles or electromagnetic radiation that can be absorbed in a coating on the plate to thereby generate heat. One method of imaging thermal plates employs infrared radiation via an IR laser.

25 So-called Computer-To-Plate ("CTP") technology has in part been responsible for a move towards thermal lithographic plates. The required pattern in the coating on the lithographic plate may be "written" by an infrared laser, under digital control.

30 Two principal classes of thermal plates are now commercially available. Positive working thermal plates, such as the ELECTRA plate of Kodak Polychrome Graphics, may be exposed by imagewise heating of regions of the plate coating, typically by exposure to imaging infrared radiation, rendering to these regions more soluble in a developer and,

thereby, more readily removed by a developer. This class of plates is disclosed in, for example, the PCT patent application published under the number WO 97/39894.

Negative working thermal plates, on the other hand, may be exposed to imaging infrared 5 radiation as previously described for positive plates. They are then subjected to an overall heating step after imaging but before development. This is typically referred to as a "preheat step." This heating step is believed to selectively crosslink those regions of the coating that were selectively imaged, rendering them preferentially less soluble in a developer. Thus, on development or processing of such a plate, the regions that were not 10 imaged are selectively developed away. A typical example of such a plate is the THERMAL PRINTING PLATE/830 of Kodak Polychrome Graphics. The technology typically utilised in these plates is disclosed in, for example, US Patent Nos. 5,340,699, 5,372,907 and 5,491,046, and can involve the use of an imaging layer comprising a resole resin, a Novolak resin, a latent Bronsted acid and an infrared absorber. The contents of 15 these patents are incorporated herein by reference.

These negative-working plates are commonly imagewise exposed by near infrared laser light at 780-1400 nm, then pre-heated in an oven to about between 100 and 200°C for between 20 about one and three minutes before processing through a processor that sequentially provides the following:

1. an alkaline developer bath;
2. a rinse section; and
3. a gumming section;

which can be in an integrated processor. The plate can then be mounted on a lithographic 25 press, whereupon many tens of thousands of prints may be obtained, although this is typically limited to 250,000 copies before the plate image is worn out. If extra copies are desired from the plate, it is known to transport the plate through a forced air oven heat the plate further, following the processing step, typically at about 285°C for about 2 minutes. This process, called "post baking," can extend the life of the plate on the press to over 30 1,000,000 copies.

However, this baking process suffers from significant disadvantages in that it uses a very large oven that consumes a significant amount of electrical power with the attendant cost

implications. A further disadvantage is that it has resulted in excessive or uneven heating, which can make the baked plate wavy and difficult to accurately mount on to the press. A third difficulty is that a protective gum is applied to the plate before baking, according to a widely known process sometimes referred to as the Thermotect® process, to prevent 5 background contamination occurring during the post-baking treatment. This gum is then removed and a normal plate finisher applied if the plate is to be stored before printing, thereby requiring further time and labour to be expended. Indeed, it is generally also necessary to remove plate finisher applied following the development process before applying the protective gum prior to baking, thereby introducing even further delays and 10 inefficiencies into the process. Notwithstanding these problems, however, plates of this type are generally baked in order to achieve greater run lengths on the press, thereby facilitating production of the desired number of copies at the end of the print run.

Consequently, it would be significantly advantageous if a treatment could be devised that 15 overcame the disadvantages associated with post-baking methods whilst still allowing for some or all of their significant benefits, including increased run lengths, to be achieved.

### Summary of the Invention

20 The present invention can include a method for improving the durability of an image on an imaging material including directing infrared radiation upon exposed areas of the imaging material after the imaging material has been processed. According to the present invention, the improved durability due to the incidence of that IR radiation is significant.

25 More specifically, the present invention can include a method for increasing the press run length of a printing plate by directing infrared radiation upon image-wise exposed areas of a developed printing plate. This method can further include imagewise exposing the printing plate to form an exposed printing plate and developing the exposed printing plate to provide the developed printing plate. At least one of the directing and developing steps can take 30 place off press or on press. Directing the infrared radiation can involve flooding the developed printing plate with infrared radiation or raster scanning infrared radiation onto the developed printing plate. The raster scanning can involve retracing the image that was

applied during an image-wise exposure or can involve scanning across substantially the entire imaging area of the developed printing plate.

5 The infrared radiation can be supplied by infrared lamps positioned adjacent the developed printing plate. The lamps can emit infrared radiation having a wavelength of about 780 nm to about 1400 nm or, more specifically, in a range of about 800 nm to about 850 nm.

10 The infrared radiation can heat the developed printing plate to a temperature in the range from about 140°C to about 160°C. The infrared radiation can be incident upon the developed printing plate for about 15 seconds to about 25 seconds.

15 The present invention can further include heating and cooling the printing plate before the printing plate is developed. Similarly, it can include rinsing the developed printing plate and applying a finisher to the developed printing plate.

20 The developed printing plate can be a negative-working lithographic printing plate, including but not limited to a thermally-imageable plate. The present invention can be applied to imaging materials other than printing plates.

25 The present invention can include controlling heating of the developed printing plate by controlling at least one of dwell time of the exposed material when adjacent the infrared radiation source, distance of the infrared source from the image-receptive material, output of the infrared radiation source.

30 The present invention can involve an apparatus for using one or more of the approaches described above. For example, it can include infrared lamps that emit infrared radiation in the range of about 780 nm to about 1400 nm. It can include an imaging device for image-wise exposing the printing plate and a processor for developing the printing plate. Still further invention can be used with or include a printing press. Still further the apparatus can include a cooling device, a rinse applicator, and/or a finisher applicator.

Generally, one embodiment of the present invention seeks to provide a method and apparatus that facilitates the treatment of imaged coatings on substrates such that significant

toughening of the images occurs, i.e., increased press run lengths of printing plates or other measure of durability. Further, this embodiment seeks to eliminate or at least reduce inefficiencies in terms of cost and labour and the burdensome expenses associated with known post-baking methods. It has now surprisingly been found that such improvements

5 may be achieved by means of an application or treatment of primarily infrared radiation following the processing (e.g., development or etching) of the imaging materials. The imaging materials on which the inventive apparatus and method can be used includes but is not limited to printing plates and resists, such as those used in the manufacture of electronic parts like printed circuit boards.

10

Thus, according to a first aspect of the present invention there is provided an apparatus for the production of an imaged material, said apparatus comprising:

15

- (a) an imaging device;
- (b) a bake oven;
- (c) a processor; and
- (d) a post-process treatment unit

20 characterised in that the post-process treatment unit comprises a unit comprising an infrared radiation source adapted to heat the imaged material to improve durability or toughening of the image.

25 Note that a similar embodiment of the above-noted invention could be to omit the bake oven in (b). Similarly, another embodiment can include a rinsing section (e.g., water), which are known in the industry, to remove extraneous debris and a gumming section to apply a suitable gum, thereby facilitating storage of the material for a longer period of time before use.

30 The apparatus can find particular applicability in the case of negative-working imaged materials, especially thermally imaged negative-working imaged materials. Most particularly, the apparatus is highly beneficial in the production of thermally imaged negative working lithographic printing plates, especially for which long run lengths are desired.

Specifically, the apparatus has particular application to thermal printing plates having imaging sensitivity in the region of between about 780 and about 1400 nm and specifically between about 800-900 nm and still more specifically about 830 nm, especially plates such as Thermal Plate 830, DITP Gold and Thermal Gold from Kodak Polychrome Graphics and

5 Thermal News, a photopolymer plate from Kodak Polychrome Graphics. Normally the novolak-type compositions used in plates such as the Thermal Plate 830 and similar plate compositions need to be raised to above about 200°C for significant periods of time to effect such an increase in press life. However, the apparatus according to the invention may be used in conjunction with any lithographic plate or photolithographic assembly where  
10 increased resistance to etching may be advantageous such as, for example, microlithography for printed circuit board or silicon chip manufacture.

In the case of printing plates, the further treatment provides increased resistance to harsh press conditions so that run length are generally increased to over 1,000,000 copies, which is  
15 similar to the run lengths achieved by the conventional lengthy baking procedure.

One embodiment having an infrared radiation source or emitter includes infrared lamps, such as short wavelength infrared lamps outputting IR-A light at a wavelength of about 780-1400 nm. The temperature achieved by means of this treatment or another infrared radiation  
20 embodiment can generally be in the range from about 140° to about 195°C, and can be controlled to be in the range from about 145° to about 165°C and should ideally be as close as possible to 155°C. Generally speaking, the plate is preferably not heated to above an upper limit such that one or more of its materials are adversely affected (e.g., buckling of the aluminum substrate) and not heated to below a lower limit such that insufficient conversion  
25 of the imaging chemistry occurs. Control can be accomplished through testing based on radiation output, distance, line speed, etc., through a feedback loop involving, for example, temperature sensors and programmable controllers, or through a combination thereof.

The dwell time at the desired temperature can be in the range from about 15 to about 25  
30 seconds, preferably from about 18 to about 22 seconds, but most preferably as close as possible to about 20 seconds to provide a balance between achieving significant toughening of the image and maintaining satisfactory throughput speed. The transport speed of the imaging material relative to the infrared lamps can be modified based on the length of a bank

of infrared lamps used in a production line, although a short length of imaging material could instead be placed under one or more infrared lamps (that could move or be stationary) and remain there for the desired dwell time. In one embodiment, ten lamps can be used and placed between 25 and 200 millimeters from the surface of the plate. Such infrared lamps  
5 are available from Victory Lighting and referred to as horizontal burn, 1.35kW, 230V, 2800K lamp, color.

Following the exposure treatment of infrared radiation, the imaged material can be rinsed with water, and a plate finisher can be applied with known applicators. The rinsing operation  
10 is generally performed by means of spraying jets of water on to the material, whilst the finisher is typically applied by passing the material, using powered rollers, through a bath containing the finisher. Any suitable commercially available finisher may be used for this purpose.

15 It is worth expressing that one embodiment of the present invention uses infrared radiation to be directed incidence upon IR-sensitive reactants and to heat the reactants. The IR lamps can provide both aspects. The specific "amount" of each aspect can be modified to affect or optimize the treatment in one manner or another.

20 The imaging device in the apparatus according can comprise any suitable imaging or exposure device of the types known to those skilled in the art. Typically, it comprises a laser or ultra-violet imaging device, for example a platesetter or phototypesetter.

25 The pre-bake (or pre-process) oven can comprise a large oven, such as a fan or forced air oven, heated to a suitable temperature or, alternatively the oven and processor may be comprised in an integrated pre-heat/processor apparatus, such as the PHW 32 processor sold by Technigraph of Thetford, UK and the INTERPLATER 85 HD/135 HD Polymer processor available from Glunz & Jensen. However, many such combination devices are primarily designed for conventionally imaged negative working lithographic plates such as the Vitesse  
30 plate of Kodak Polychrome Graphics and may be less suitable for use with thermally imaged plates, since they tend to give rise to a temperature gradient that rises, for example, from the front to the rear of a plate in the preheat oven and, potentially, that rises exponentially in the rearwards direction. Other means for pre-develop heating could be used.

Evidently, conventionally imaged negative working lithographic plates are sufficiently robust that they can be used in pre-bake ovens of this type, but thermal plates are more susceptible to damage under such conditions. For example, it is believed that "fogging" at 5 the trailing edge region and lower temperature at the leading edge can lead to unacceptable performance.

Consequently, it is preferred that a pre-bake oven specifically designed for use with thermally imaged materials should be employed for the purposes of the present invention. 10 Preferably the pre-bake oven should be capable of controlling, and more preferably reducing, the amount of heat applied to the imaged material as the material progresses through the oven. It is desirable that the amount of heat applied to the imaged material should be reduced as it progresses through the pre-bake oven in order to prevent the temperature gradient, and resultant fogging, previously discussed. With the class of thermal printing 15 plates which include photo sensitizers, a substantial temperature difference from one end of the plate to the other will cause different degrees of crosslinking which can give rise to different dot sizes along the plate and even a small temperature difference can be very detrimental. Or, the plate may look the same in terms of size of dot after development, but portions of the plate may exhibit lesser or greater degrees of durability and result in poor run 20 length on printing.

The temperature control within the pre-bake oven may be such that the heat transferred to the imaged material as it progresses through the oven is reduced to compensate, at least in part, for the propensity for heat to build up towards the trailing edge of the material. Preferably 25 the compensation is such that the temperature along the length of the material is substantially consistent, or at least is such that there is a reduced temperature differential within the material, within limits acceptable for the material in question. For example, a temperature difference between regions of the material of no more than about 30°C may be acceptable. However, it is preferably not more than about 20°C, about 10°C, about 5°C, or even about 30 2°C.

Various temperature control means are available in order to achieve the said objectives. Preferably, however, the temperature can be controlled by means of a controllable

mechanical barrier, which is provided between heat-emitting parts of the pre-bake oven and the imaged material progressing through the oven, the barrier being selectively operable to reduce the amount of heat applied to the material as it progresses through the oven. In addition to that temperature controlling approach, known temperature sensors and 5 programmable controllers could be used in an oven or in conjunction with infrared lamps.

In the case of thermally imaged materials, it is not necessary that the pathway between the pre-bake oven and the processor should pass through a wash section. However, the said pathway may be such that the imaging material passes through a cooling section, which 10 preferably comprises means for delivering coolant to the imaged material.

Coolant may be air, and it is normally adequate if the coolant is at room temperature (i.e., approximately 21°C), although air at above or below room temperature may be used to cool the imaging material. The coolant may comprise a series of fluid jets directed onto, toward 15 or adjacent the imaged material, but preferably it comprises a sheet of coolant directed onto the material, for example issuing from a slit arranged transverse to the direction of travel, although non-transverse arrangements may be used to change the cooling performance to possibly match a heating inconsistency. Also, rather than slits, a series of small holes may be used or some combination thereof. Thus, a cooling device may be a form of "air knife" 20 directed onto the surface of the material. The cooling section may further comprises a pair of rollers between the pre-bake section and the processor, between which the material is conveyed.

Another cooling approach could involve causing the heated imaging material to contact a 25 cooler surface such as a chilled plate or a chilled roller. That is, heat could be removed more through conduction than convection. Combinations of conductive and convective cooling are also contemplated.

The processor, or developing apparatus, can comprise any suitable processing device of the 30 type known to those skilled in the art, such as the Mercury series of processors from Kodak Polychrome Graphics. The processor is a machine which serves to apply a fluid, often called a developer solution to the surface of the imaged element in order to remove and/or loosen the unexposed coating in the non-image areas and can optionally subsequently rinse

the developed treated material in order to wash away the fluid or developer and any loosened or removed coating.

Typically, the developer is contained in a bath, through which the imaged material is  
5 propelled by means of powered rollers. The developer may comprise any suitable solution capable of removing the unexposed coating known to those skilled in the art. Generally, in the case of thermally imageable materials, the developer comprises an alkaline solution.

10 The developed material is conventionally rinsed with water, and the rinsing section of the processor usually operates by means of spraying jets of water on to the material.

A second aspect or embodiment of the present invention involves a method for preparing an imaged material, one embodiment of said method comprising the steps of:

15 (a) imagewise exposing an imaging material by means of laser light or ultra-violet radiation;  
(b) pre-baking the imaged material in an oven;  
(c) processing the imaged material; and  
(d) treating the imaged material after processing.

20 characterised in that the treating step comprises exposing the imaged material to infrared radiation in order to achieve toughening of the image.

25 Note that a similar embodiment of the above-noted invention could be to omit the bake oven in (b). Also, an embodiment of the present invention could employ a rinsing step using known rinsing equipment.

30 Imaged materials produced according to the method of the second aspect of the invention are found to have significantly improved performance when compared with materials which are obtained in the absence of the post-treatment step. Specifically, in the case of thermally imaged lithographic printing plates, the run length of the plates when employed on a printing press shows a marked improvement, and print runs in excess of one million copies are regularly achieved, which is significantly more than without the treating step. Further, as

noted above, a cooling step following the pre-baking step could be employed as could other steps.

When comparing the apparatus and method of the invention with prior art systems that 5 employ a post-baking step, it is found that imaged materials may be obtained with significant savings in terms of cost and labour, and marked improvements in overall efficiency. This may be illustrated by a simple comparison of the systems of the prior art and of the present invention. Thus, a conventional process would comprise the following steps:

- 10 1. Imagewise exposure;
2. Pre-bake at 150°C;
3. Process
  - (a) Develop
  - (b) Rinse with Water
  - (c) Apply Plate Finisher;
- 15 4. Wash off Plate Finisher;
5. Apply Protective Gum;
6. Post Bake for 2 Minutes at 285°C;
7. Remove Protective Gum;
- 20 8. Apply Plate Finisher.

By way of contrast, one embodiment of the inventive method can comprise the following steps:

- 25 1. Imagewise exposure;
2. Pre-bake at 150°C;
3. Process
  - (a) Develop
  - (b) Rinse with Water;
- 30 4. Post-treat
  - (a) Expose to Infrared Radiation;
  - (b) Rinse with Water
  - (c) Apply Plate Finisher.

As noted above, a similar embodiment of the present invention can omit step 2 (Pre-Bake). That embodiment or another similar embodiment can omit step 3(b) (Rinse with Water) and/or step 4(b) (Rinse with Water), and so on. In still another embodiment, a step 3(c) 5 could be included, which would be to "Apply Plate Finisher."

In addition to the various embodiments noted above, it will be apparent to those skilled in the art that various alterations, variations, combinations, and modifications may be made to the described embodiments without departing from the scope of the invention.

10

#### **Brief Description of Drawings**

Other objects and advantages of the invention will become apparent upon reading the following detailed description and upon reference to the drawings in which:

15

Figure 1 schematically shows a known production line for imaging, developing, and post-baking an imaging material, such as a thermally-imaged, negative-working imaging material; and

20 Figure 2 schematically shows an embodiment of the present invention for post-treating an imaging material using primarily infrared radiation.

Figure 3 schematically shows the interior of the embodiment of the invention shown in Figure 2, including an imaging material being driven beneath a bank of infrared lamps.

25

Figure 4 schematically shows an alternative embodiment of the present invention in which infrared lamps are positioned to flood expose a printing plate mounted on a cylinder.

### Detailed Description of Preferred Embodiments of the Invention

The following disclosure describes a number of embodiments of the invention, though other variations or combinations of various noted aspects of these embodiments and still other 5 aspects are contemplated by the inventors as part of the invention.

Generally, one embodiment of the present invention seeks to provide a method and apparatus that facilitates the treatment of imaged coatings on substrates such that significant 10 toughening of the images occurs, i.e., increased press run lengths of printing plates or other measure of durability. Further, this embodiment seeks to eliminate or at least reduce inefficiencies in terms of cost and labour and the burdensome expenses associated with known post-baking methods. It has now surprisingly been found that such improvements 15 may be achieved by means of an application or treatment of primarily infrared radiation following the processing (e.g., development or etching) of the imaging materials. The imaging materials on which the inventive apparatus and method can be used includes but is not limited to printing plates and resists, such as those used in the manufacture of electronic parts like printed circuit boards.

Thus, according to a first aspect of the present invention there is provided an apparatus for 20 the production of an imaged material, said apparatus comprising:

- (a) an imaging device;
- (b) a bake oven;
- (c) a processor; and
- 25 (d) a post-process treatment unit

characterised in that the post-process treatment unit comprises a unit comprising an infrared radiation source adapted to heat the imaged material to improve durability or toughening of the image.

30

Note that a similar embodiment of the above-noted invention could be to omit the bake oven in (b). Similarly, another embodiment can include a rinsing section (e.g., water), which are known in the industry, to remove extraneous debris and a gumming section to apply a

suitable gum, thereby facilitating storage of the material for a longer period of time before use.

5 The apparatus can find particular applicability in the case of negative-working imaged materials, especially thermally imaged negative-working imaged materials. Most particularly, the apparatus is highly beneficial in the production of thermally imaged negative working lithographic printing plates, especially for which long run lengths are desired.

10 Specifically, the apparatus has particular application to thermal printing plates having imaging sensitivity in the region of between about 780 and about 1400 nm and specifically between about 800-900 nm and still more specifically about 830 nm, especially plates such as Thermal Plate 830, DITP Gold and Thermal Gold from Kodak Polychrome Graphics and Thermal News, a photopolymer plate from Kodak Polychrome Graphics. Normally the novolak-type compositions used in plates such as the Thermal Plate 830 and similar plate 15 compositions need to be raised to above about 200°C for significant periods of time to effect such an increase in press life. However, the apparatus according to the invention may be used in conjunction with any lithographic plate or photolithographic assembly where increased resistance to etching may be advantageous such as, for example, microlithography for printed circuit board or silicon chip manufacture.

20 In the case of printing plates, the further treatment provides increased resistance to harsh press conditions so that run length are generally increased to over 1,000,000 copies, which is similar to the run lengths achieved by the conventional lengthy baking procedure.

25 One embodiment having an infrared radiation source or emitter includes infrared lamps, such as short wavelength infrared lamps outputting IR-A light at a wavelength of about 780-1400 nm. The temperature achieved by means of this treatment or another infrared radiation embodiment can generally be in the range from about 140° to about 195°C, and can be controlled to be in the range from about 145° to about 165°C and should ideally be as close 30 as possible to 155°C. Generally speaking, the plate is preferably not heated to above an upper limit such that one or more of its materials are adversely affected (e.g., buckling of the aluminum substrate) and not heated to below a lower limit such that insufficient conversion of the imaging chemistry occurs. Control can be accomplished through testing based on

radiation output, distance, line speed, etc., through a feedback loop involving, for example, temperature sensors and programmable controllers, or through a combination thereof.

The dwell time at the desired temperature can be in the range from about 15 to about 25 seconds, preferably from about 18 to about 22 seconds, but most preferably as close as possible to about 20 seconds to provide a balance between achieving significant toughening of the image and maintaining satisfactory throughput speed. The transport speed of the imaging material relative to the infrared lamps can be modified based on the length of a bank of infrared lamps used in a production line, although a short length of imaging material could instead be placed under one or more infrared lamps (that could move or be stationary) and remain there for the desired dwell time. In one embodiment, ten lamps can be used and placed between 25 and 200 millimeters from the surface of the plate. Such infrared lamps are available from Victory Lighting and referred to as horizontal burn, 1.35kW, 230V, 2800K lamp, color.

15

Following the exposure treatment of infrared radiation, the imaged material can be rinsed with water, and a plate finisher can be applied with known applicators. The rinsing operation is generally performed by means of spraying jets of water on to the material, whilst the finisher is typically applied by passing the material, using powered rollers, through a bath containing the finisher. Any suitable commercially available finisher may be used for this purpose.

20 It is worth expressing that one embodiment of the present invention uses infrared radiation to be directed incidence upon IR-sensitive reactants and to heat the reactants. The IR lamps can provide both aspects. The specific "amount" of each aspect can be modified to affect or 25 optimize the treatment in one manner or another.

30 The imaging device in the apparatus according can comprise any suitable imaging or exposure device of the types known to those skilled in the art. Typically, it comprises a laser or ultra-violet imaging device, for example a platesetter or phototypesetter.

The pre-bake (or pre-process) oven can comprise a large oven, such as a fan or forced air oven, heated to a suitable temperature or, alternatively the oven and processor may be

comprised in an integrated pre-heat/processor apparatus, such as the PHW 32 processor sold by Technigraph of Thetford, UK and the INTERPLATER 85 HD/135 HD Polymer processor available from Glunz & Jensen. However, many such combination devices are primarily designed for conventionally imaged negative working lithographic plates such as the Vitesse 5 plate of Kodak Polychrome Graphics and may be less suitable for use with thermally imaged plates, since they tend to give rise to a temperature gradient that rises, for example, from the front to the rear of a plate in the preheat oven and, potentially, that rises exponentially in the rearwards direction. Other means for pre-develop heating could be used.

10 Evidently, conventionally imaged negative working lithographic plates are sufficiently robust that they can be used in pre-bake ovens of this type, but thermal plates are more susceptible to damage under such conditions. For example, it is believed that "fogging" at the trailing edge region and lower temperature at the leading edge can lead to unacceptable performance.

15 Consequently, it is preferred that a pre-bake oven specifically designed for use with thermally imaged materials should be employed for the purposes of the present invention. Preferably the pre-bake oven should be capable of controlling, and more preferably reducing, the amount of heat applied to the imaged material as the material progresses through the 20 oven. It is desirable that the amount of heat applied to the imaged material should be reduced as it progresses through the pre-bake oven in order to prevent the temperature gradient, and resultant fogging, previously discussed. With the class of thermal printing plates which include photo sensitizers, a substantial temperature difference from one end of the plate to the other will cause different degrees of crosslinking which can give rise to 25 different dot sizes along the plate and even a small temperature difference can be very detrimental. Or, the plate may look the same in terms of size of dot after development, but portions of the plate may exhibit lesser or greater degrees of durability and result in poor run length on printing.

30 The temperature control within the pre-bake oven may be such that the heat transferred to the imaged material as it progresses through the oven is reduced to compensate, at least in part, for the propensity for heat to build up towards the trailing edge of the material. Preferably the compensation is such that the temperature along the length of the material is substantially

consistent, or at least is such that there is a reduced temperature differential within the material, within limits acceptable for the material in question. For example, a temperature difference between regions of the material of no more than about 30°C may be acceptable. However, it is preferably not more than about 20°C, about 10°C, about 5°C, or even about 5 2°C.

Various temperature control means are available in order to achieve the said objectives. Preferably, however, the temperature can be controlled by means of a controllable mechanical barrier, which is provided between heat-emitting parts of the pre-bake oven and 10 the imaged material progressing through the oven, the barrier being selectively operable to reduce the amount of heat applied to the material as it progresses through the oven. In addition to that temperature controlling approach, known temperature sensors and programmable controllers could be used in an oven or in conjunction with infrared lamps.

15 In the case of thermally imaged materials, it is not necessary that the pathway between the pre-bake oven and the processor should pass through a wash section. However, the said pathway may be such that the imaging material passes through a cooling section, which preferably comprises means for delivering coolant to the imaged material.

20 Coolant may be air, and it is normally adequate if the coolant is at room temperature (i.e., approximately 21°C), although air at above or below room temperature may be used to cool the imaging material. The coolant may comprise a series of fluid jets directed onto, toward or adjacent the imaged material, but preferably it comprises a sheet of coolant directed onto the material, for example issuing from a slit arranged transverse to the direction of travel, 25 although non-transverse arrangements may be used to change the cooling performance to possibly match a heating inconsistency. Also, rather than slits, a series of small holes may be used or some combination thereof. Thus, a cooling device may be a form of "air knife" directed onto the surface of the material. The cooling section may further comprises a pair of rollers between the pre-bake section and the processor, between which the material is 30 conveyed.

Another cooling approach could involve causing the heated imaging material to contact a cooler surface such as a chilled plate or a chilled roller. That is, heat could be removed more

through conduction than convection. Combinations of conductive and convective cooling are also contemplated.

The processor, or developing apparatus, can comprise any suitable processing device of the type known to those skilled in the art, such as the Mercury series of processors from Kodak Polychrome Graphics. The processor is a machine which serves to apply a fluid, often called a developer solution to the surface of the imaged element in order to remove and/or loosen the unexposed coating in the non-image areas and can optionally subsequently rinse the developed treated material in order to wash away the fluid or developer and any loosened or removed coating.

Typically, the developer is contained in a bath, through which the imaged material is propelled by means of powered rollers. The developer may comprise any suitable solution capable of removing the unexposed coating known to those skilled in the art. Generally, in the case of thermally imageable materials, the developer comprises an alkaline solution.

The developed material is conventionally rinsed with water, and the rinsing section of the processor usually operates by means of spraying jets of water on to the material.

A second aspect or embodiment of the present invention involves a method for preparing an imaged material, one embodiment of said method comprising the steps of:

- (a) imagewise exposing an imaging material by means of laser light or ultra-violet radiation;
- (b) pre-baking the imaged material in an oven;
- (c) processing the imaged material; and
- (d) treating the imaged material after processing.

characterised in that the treating step comprises exposing the imaged material to infrared radiation in order to achieve toughening of the image.

Note that a similar embodiment of the above-noted invention could be to omit the bake oven in (b). Also, an embodiment of the present invention could employ a rinsing step using known rinsing equipment.

5    Imaged materials produced according to the method of the second aspect of the invention are found to have significantly improved performance when compared with materials which are obtained in the absence of the post-treatment step. Specifically, in the case of thermally imaged lithographic printing plates, the run length of the plates when employed on a printing press shows a marked improvement, and print runs in excess of one million copies are

10    regularly achieved, which is significantly more than without the treating step. Further, as noted above, a cooling step following the pre-baking step could be employed as could other steps.

When comparing the apparatus and method of the invention with prior art systems that employ a post-baking step, it is found that imaged materials may be obtained with significant savings in terms of cost and labour, and marked improvements in overall efficiency. This may be illustrated by a simple comparison of the systems of the prior art and of the present invention. Thus, a conventional process would comprise the following steps:

20            1.    Imagewise exposure;

                  2.    Pre-bake at 150°C;

                  3.    Process

                    (a)    Develop

                    (b)    Rinse with Water

                    (c)    Apply Plate Finisher;

25            4.    Wash off Plate Finisher;

                  5.    Apply Protective Gum;

                  6.    Post Bake for 2 Minutes at 285°C;

                  7.    Remove Protective Gum;

30            8.    Apply Plate Finisher.

By way of contrast, one embodiment of the inventive method can comprise the following steps:

1. Imagewise exposure;
2. Pre-bake at 150°C;
3. Process

5 (a) Develop

(b) Rinse with Water;

4. Post-treat

(a) Expose to Infrared Radiation;

(b) Rinse with Water

10 (c) Apply Plate Finisher.

As noted above, a similar embodiment of the present invention can omit step 2 (Pre-Bake) . That embodiment or another similar embodiment can omit step 3(b) (Rinse with Water) and/or step 4(b) (Rinse with Water), and so on. In still another embodiment, a step 3(c) 15 could be included, which would be to "Apply Plate Finisher."

Thus, the greater practicality of the method of the present invention is clearly apparent, and the corresponding benefits which accrue in terms of the scaling down of the apparatus are apparent from Figures 1 and 2.

20 Figure 1 shows part of a conventional production line used for the preparing a thermally imaged negative-working imaging materials. Figure 2 shows a post treatment unit as employable, for example, in the apparatus according to the first aspect of the present invention, drawn to the same scale as Figure 1.

25 Considering Figure 1, which would typically be used for the processing of lithographic printing plates, there is shown a conveyor section 1 which feeds the imaged plate to a processor 2, which contains developer and wherein development of the plate occurs prior to passage through rinse unit 3 and processor 4, containing plate finisher. Printing plates that 30 are to be used for short print runs are taken from the line at this point and do not undergo post-baking. However, plates that are required to perform longer print runs and require a post-baking treatment continue through rinse unit 5, which removes the plate finisher, before entering processor 6, wherein a protective gum or so-called "pre-bake solution" is applied.

The plates are then baked in oven 7, after which the protective gum is removed in rinse unit 8 and plate finisher is again applied by passing through processor 9, the final printing plated being collected in stacker 10. Clearly, the section of this processing of post-baked plates wherein plate finisher is applied after development, only to be removed again in order that a 5 protective gum may be applied prior to post-baking, represents a waste of time and materials. However, this can be less costly than rearranging the production line on every occasion or certain occasions when production is to be changed from short run (non-post-baked) plates to long run (post-baked) plates.

10 Turning now to the embodiment shown in Figures 2 and 3, there is shown a post-developer treatment unit 1 wherein an imaged, developed plate P is exposed to infrared radiation via one or more infrared lamps L, then, for example, can be rinsed with water and finally treated with a plate finisher. This unit can be aligned downstream of a processor and rinse unit (such as 2 and 3 in Figure 1), and upstream of a stacker (such as 10 in Figure 1) and the 15 resulting combination then serves to provide similarly positive run-length results as those provided by the lengthy processing line of Figure 1. As noted above, it can eliminate one or more time-consuming and costly steps and structure used in known methods and apparatus.

20 Other in-line and off-line arrangements can be employed to make use of the inventive treatment. Further, Figure 4 shows a cylinder C around which a printing plate can be positioned and adjacent which one or more infrared lamps L can be positioned to treat the printing plate according to the present invention. This embodiment or a variation of it could be used, for example, in conjunction with on-press development and treatment. That is, a printing plate that is being developed on-press can likewise be treated according to the 25 present invention while being on-press. Such an arrangement could involve developing the plate with a press liquid (e.g., water, ink, etc.), squeezing off or drying off the liquid (or allowing it to transfer off), then treating the developed plate. Still further variations on these approaches are envisioned. As a result of the above, an embodiment of the present invention can include known on-press development steps (as part of the inventive method) and known 30 printing presses (as part of the apparatus).

Although the invention has been described in terms of the foregoing embodiments, it will be apparent to those skilled in the art that various alterations, variations, combinations, and

modifications may be made to the described embodiments without departing from the scope of the invention. For example, one or more methods, steps of methods, apparatus, and structure of apparatus described above can be combined into fewer methods, steps, apparatus, or structure, or broken out into more methods, steps, apparatus, or structure. The 5 disclosed embodiments are provided merely by way of example.

For example, heat can be contributed to the plates by running the developed plate over a heated platen, rollers, or belt. Other conductive heating approaches (or convective or radiative heating approaches) could be employed. These alternative heating approaches can 10 be used in conjunction with the heat provided by the IR lamps.

**CLAIMS**

5 1. A method for improving the durability of an image on an imaging material, comprising directing infrared radiation upon exposed areas of a processed imaging material.

10 2. The method of claim 1, wherein the processed imaging material comprises a developed printing plate and wherein improving durability of the imaging material increases the press run length of the printing plate.

15 3. The method of claim 2 further comprising:  
      imagewise exposing the printing plate to form an exposed printing plate; and  
      developing the exposed printing plate to provide the developed printing plate.

20 4. The method of claim 3, wherein at least one of the directing and developing steps is carried out off press.

25 5. The method of claim 3, wherein at least one of the directing and developing steps is carried out on press.

6. The method of claim 2, wherein the step of directing comprises at least one of flooding the developed printing plate with infrared radiation and raster scanning infrared radiation onto the developed printing plate.

30 7. The method of claim 2, wherein the directing step comprising positioning infrared lamps adjacent the developed printing plate, wherein the infrared lamps emit infrared radiation having a wavelength of about 780 nm to about 1400 nm.

8. The method of claim 7, wherein the infrared lamps emit infrared radiation having a wavelength in a range of about 800 nm to about 850 nm.

9. The method of claim 2, wherein the directing step heats the developed printing plate to a temperature in the range from about 140°C to about 160°C.
10. The method of claim 2, wherein the directing step comprises directing the infrared radiation incident upon the developed printing plate for about 15 seconds to about 25 seconds.
11. The method of claim 2, further comprising:
  - heating the printing plate before the printing plate is developed;
  - cooling the printing plate before the printing plate is developed;
  - rinsing the developed printing plate; and
  - applying a finisher to the developed printing plate.
12. The method of claim 2, wherein the developed printing plate comprises a thermally-imageable, negative-working lithographic printing plate.
13. The method of claim 2, further comprising controlling heating of the developed printing plate by controlling at least one of dwell time of the exposed material when adjacent the infrared radiation source, distance of the infrared source from the image-receptive material, output of the infrared radiation source.
14. The method of claim 1, wherein the processed imaging material comprises a processed resist, and wherein the method further comprises:
  - imagewise exposing the resist to form an exposed resist; and
  - etching the exposed resist to form the processed resist.
15. An imaging material prepared by the method of claim 1.
16. A negative-working printing plate prepared by the method of claim 2.
17. A resist prepared by the method of claim 14.
18. An apparatus for using the method of claim 1.

19. An apparatus for the production of an imaged material, said apparatus comprising:

- (a) an imaging device;
- (b) an optional bake oven;
- 5 (c) a processor; and
- (d) a post-process treatment unit

characterized in that the post-process treatment unit comprises a unit comprising an infrared radiation source adapted to heat the imaged material to improve durability or toughening of the image.

10

20. The apparatus of claim 18 or 19 comprising an infrared lamp that emit infrared radiation in the range of about 780 nm to about 1400 nm.

15

21. The apparatus of claim 18 or 19, wherein the imaging material comprises a printing plate, and wherein the apparatus further comprises an imaging device for image-wise exposing the printing plate and a processor for developing the printing plate.

20

22. The apparatus of claim 18 or 19, wherein the imaging material comprises a printing plate, and wherein the apparatus further comprises a printing press.

25

23. The apparatus of claim 18 or 19, further comprising at least one of a cooling device, a rinse applicator, and a finisher applicator.

25

24. The apparatus of claim 18 or 19, wherein the imaging material comprises a resist, and wherein the apparatus further comprises an imaging device for image-wise exposing the resist and a processor for etching the resist.

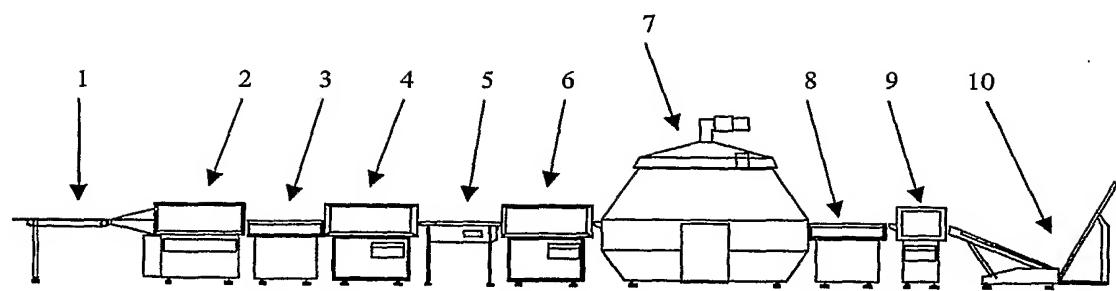


Figure 1 Standard processing line

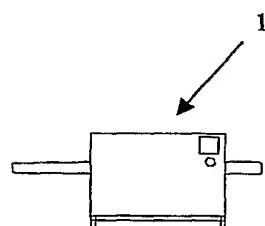


Figure 2 Post treatment unit

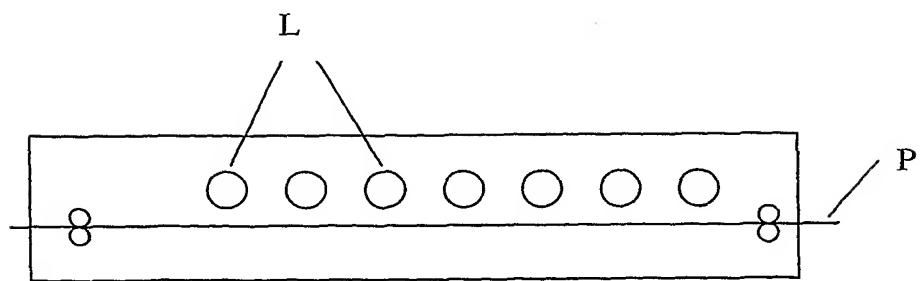


Fig. 3

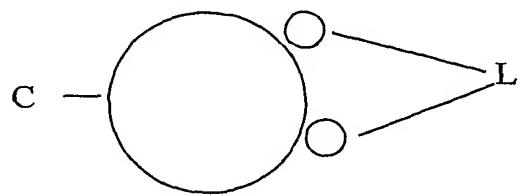


Fig. 4

# INTERNATIONAL SEARCH REPORT

International Application No  
PCT/EP 03/07797

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 G03F/40

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 G03F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category <sup>o</sup>	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 19 55 378 A (KALLE AG) 13 May 1971 (1971-05-13) the whole document ---	1-13,15, 16,18-23
X	GB 2 205 419 A (HORSELL GRAPHIC IND LTD) 7 December 1988 (1988-12-07) the whole document ---	1-13,15, 16,18-23
X	DE 26 48 438 B (EPPING REINHOLD H DIPL PHYS DR) 12 January 1978 (1978-01-12) the whole document ---	1-13,15, 16,18-23
X	DE 22 01 936 A (KALLE AG) 19 July 1973 (1973-07-19) the whole document ---	1-13,15, 16,18-23 -/-

Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

\* Special categories of cited documents :

- \*A\* document defining the general state of the art which is not considered to be of particular relevance
- \*E\* earlier document but published on or after the international filing date
- \*L\* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- \*O\* document referring to an oral disclosure, use, exhibition or other means
- \*P\* document published prior to the international filing date but later than the priority date claimed

- \*T\* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- \*X\* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- \*Y\* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- \*&\* document member of the same patent family

Date of the actual completion of the international search

15 March 2004

Date of mailing of the international search report

23/03/2004

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3016

Authorized officer

Vogel, T

## INTERNATIONAL SEARCH REPORT

International Application No  
PCT/EP 03/07797

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	DE 100 35 430 A (ADVANCED PHOTONICS TECHNOLOGIE) 7 February 2002 (2002-02-07) the whole document ---	1,14,15, 17-19,24
X	PATENT ABSTRACTS OF JAPAN vol. 2003, no. 03, 5 May 2003 (2003-05-05) & JP 2002 343697 A (RICOH OPT IND CO LTD), 29 November 2002 (2002-11-29) abstract the whole document ---	1,14,15, 17-19,24
A	WEISMAN D W: "Infrared drying and curing systems" METAL FINISHING, ELSEVIER SCIENCE PUBLISHING, NEW YORK, NY, US, vol. 97, no. 5, 1999, pages 362,364,366-368, XP004166852 ISSN: 0026-0576 the whole document -----	1-24

**INTERNATIONAL SEARCH REPORT**

 International Application No  
 PCT/EP 03/07797

Patent document cited in search report	Publication date	Patent family member(s)		Publication date
DE 1955378	A 13-05-1971	DE 1955378 A1 AT 308777 B BE 758409 A1 CA 936035 A1 ES 385140 A1 FR 2068977 A5 GB 1330139 A NL 7015561 A ZA 7007445 A		13-05-1971 25-07-1973 03-05-1971 30-10-1973 16-04-1973 03-09-1971 12-09-1973 06-05-1971 27-10-1971
GB 2205419	A 07-12-1988	NONE		
DE 2648438	B 12-01-1978	DE 2648438 B1		12-01-1978
DE 2201936	A 19-07-1973	DE 2201936 A1 AT 331272 B AT 27573 A BE 793979 A1 CH 569990 A5 DK 133314 B FR 2168782 A5 GB 1413374 A IT 974226 B JP 1055428 C JP 48079004 A JP 55048296 B NL 7300181 A , B, SE 384586 B		19-07-1973 10-08-1976 15-11-1975 12-07-1973 28-11-1975 26-04-1976 31-08-1973 12-11-1975 20-06-1974 23-07-1981 23-10-1973 05-12-1980 17-07-1973 10-05-1976
DE 10035430	A 07-02-2002	DE 10035430 A1 AU 8971201 A DE 20020394 U1 WO 0208836 A2		07-02-2002 05-02-2002 01-03-2001 31-01-2002
JP 2002343697	A 29-11-2002	NONE		

**PUB-NO:** WO2005015318A1  
**DOCUMENT-IDENTIFIER:** WO 2005015318 A1  
**TITLE:** APPARATUS AND METHOD FOR  
TREATING IMAGING MATERIALS  
**PUBN-DATE:** February 17, 2005

**INVENTOR-INFORMATION:**

<b>NAME</b>	<b>COUNTRY</b>
MACHUEL, GILBERT	FR
GERARD, PATRICK	FR

**ASSIGNEE-INFORMATION:**

<b>NAME</b>	<b>COUNTRY</b>
KODAK POLYCHROME GRAPHICS GMBH	DE
MACHUEL GILBERT	FR
GERARD PATRICK	FR

**APPL-NO:** EP00307797

**APPL-DATE:** July 17, 2003

**PRIORITY-DATA:** EP00307797W (July 17, 2003)

**INT-CL (IPC):** G03F007/40

**ABSTRACT:**

CHG DATE=20050301 STATUS=O>An apparatus and method for improving the durability of an image on an imaging material, including increasing the press run length or a printing plate. The apparatus and method

can involve the use of, as an example but not restricted to, an imaging device, a pre-bake oven, a processor, and a post-process treatment unit that employs infrared lamps adapted to irradiate the image.